



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-5
Job Sheet 174813



Part No: D4776-5

Job Qty: 80 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/9/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea	4/7/18	4/7/18	0.00	0.00	Start Up Machining-3		<i>18/04/02</i>
100	Doosan	80 pcs	4/7/18	4/7/18	0.05	4.47	Doosan		<i>18/04/02</i>
120	QC	80 pcs	4/7/18	4/7/18	0.00	0.00	QC8		38
130	HandFinish	80 pcs	4/9/18	4/9/18	0.00	0.39	HandFinish1		<i>SA 18-04-03</i>
140	QC	80 pcs	4/9/18	4/9/18	0.00	0.00	QC7-4		38
150	Packaging	80 pcs	4/9/18	4/9/18	0.00	0.00	Packaging3-2	<i>57/15</i>	<i>APR 04 2018</i>
160	QC21-SA	80 Ea	4/9/18	4/9/18	0.00	0.00	QC21		<i>APR 04 2018</i>

Part Op 100 - 1-Turn as per Folio and Dwg
Descriptions:

21 *APR 04 2018*
9-80

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.6000 ft (.02 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	2	42	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches $\pm$ 0.030	0.160 0.100		
2	Spacer	0.250Inches $\pm$ 0.030	0.280 0.220		
3	Spacer	0.625Inches $\pm$ 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches $\pm$ 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches $\pm$ 0.005 -0.001	0.208 0.202	Diameter	

DQA: _____ Date: _____

WORK ORDER NO

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Reworl Scrap Use-as-i Suspected Unapproved
Part No. _____	
NCR No. _____	

Date :	Step #:
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Description Work Order Deviation

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DART
AEROSPACE

Container No: S057403

Part: D4776-5

Job No: 174813

Serial No/Batch: S057403

Revision:

Inspector:

Date: 04/02/18

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QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER :					
Misidentified	☐	Past Due						